



Dart Aerospace Ltd.
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D2873-043
Job Sheet 191088



Part No: D2873-043

Job Qty: 30 ea

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	4/12/19	4/12/19	0.00	0.00	Start Up Machining-1		BT
100	Bandsaw	30 pcs	4/12/19	4/12/19	0.00	0.14	Bandsaw1		BT
110	CNC Vertical Machining	30 pcs	4/12/19	4/12/19	0.04	7.91	HAAS1-2		mmc 19/03/19
120	QC	30 pcs	4/12/19	4/12/19	0.00	0.00	QC2 Machining-1		DR 19/03/19
130	QC	30 pcs	4/12/19	4/12/19	0.00	0.00	QC8 Machining-1		DR 19/03/19
150	QC	30 pcs	4/12/19	4/12/19	0.00	0.00	QC5		MAR 12 2019
160	HandFinish	30 pcs	4/12/19	4/12/19	0.00	0.38	HandFinish1		DR 19/03/19
170	QC	30 pcs	4/12/19	4/12/19	0.00	0.00	QC7-1		58 DAS
180	Small Fab	30 pcs	4/12/19	4/12/19	0.00	1.02	Small Fab-2		58 DAS
190	QC	30 pcs	4/12/19	4/12/19	0.00	0.00	QC5		MAR 14 2019
200	Packaging	30 pcs	4/12/19	4/12/19	0.00	0.00	Packaging3-1	LG050	MAR 15 2019
210	QC21-SA	30 Ea	4/12/19	4/12/19	0.00	0.00	QC21		AB 19-3-23

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long

Descriptions: 110 - Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev ____ Folio Rev ____

180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043

200 - LOCATION : LG050

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	9.2490 ft (.3083 ea)	90-Start up Operation	5150599 X16
MS20426AD4-6	Rivet	180 Ea (6 ea)	180-Small Fab	8056024 X15
MS21075L5	Nut Plate	90 Ea (3 ea)	180-Small Fab	3083538-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X1.000	9	23	0
180-Small Fab	MS20426AD4-6	180	1,249	0
	MS21075L5	90	239	0

Part Specifications

Specifications could not be found.

Plex 2/21/19 9:29 AM Dart.lajeunesse.marie



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Container No: S159731**Part: D2873-043****Job No: 191088****Serial No/Batch: S159731****Revision:****Inspector:****Exp Date:****Instructions: Various STC's**

Date: 03/06/19

DART AEROSPACE LTD		Work Order:	191088
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	/		vern	mm-cs
2.000	+/-0.010	2.002	/			
0.750	+/-0.010	0.749	/			
1.000	+/-0.010	1.002	/			
0.250	+/-0.010	0.245	/			
1.000	+/-0.010	1.005	/			
2.000	+/-0.010	2.005	/			
3.000	+/-0.010	3.004	/			
Ø0.128	+0.005/-0.001	0.130	/			
0.359	+/-0.010	0.359	/			
Ø0.316	+0.006/-0.001	0.319	/			
1.000	+/-0.010	0.996	/			
0.250	+/-0.010	0.251	/			
0.061	+/-0.010	0.067	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.230 x 0.121	/			

Measured by:	<i>[Signature]</i>	Audited by:		Prototype Approval:	N/A
Date:	19/03/06	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	<i>[Signature]</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					